

# Work Order ID 63334

Wednesday, October 27, 2010 3:51:34 PM



Page 1

Item ID:	D2932-1UP	Accept		Setup	Start	
Revision ID:						
Item Name:	206 Saddle Left side-unpainted				Stop	
Start Date:	10/27/2010	Start Qty:	6.00			
Required Date:	11/11/2010	Req'd Qty:	6.00			
Reference:						

Approvals:	Process Plan:	Date:	10-10-25	Tooling:		Date:	
	QC:	Date:		SPC (Y/N):		Date:	

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2932	Rev C								
100	HAAS CNC VERTICAL MACHINING #1	0.00							
	HAAS 1								
HAAS CNC vertical machine #1	<b>Memo</b> Program part number and batch number. <input type="checkbox"/> 1-Inspect part number and batch number are programmed correctly. <input type="checkbox"/> 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet <input type="checkbox"/> 3-Machine Step No 2 of Folio and visually inspect as per	0.00							
110	CONVENTIONAL MILLING MACHINE	0.00							
	Mill Conv								
Conventional Milling Machine	<b>Memo</b> Machine Keyway and inspect per attached dimension sheet	0.00							
120	QC1- Inspect dimensions to dimension sheet	0.00							
	QC								
Quality Control	<b>Memo</b>	0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2932-1UP PAR #: \_\_\_\_\_ Fault Category: Machined Parts NCR: Yes No DQA: / Date: 10/12/06  
 Resolution: Accepted Disposition: USE AS IS QA: N/C Closed: / Date: 10/12/06






NCR: <u>63334</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10-11	100	.240/.270 DIMENSION UNDER TOLERANCE BY .007" (.234) ALONG WITH .063" DIMENSION 10.12.02 134.010" (.043) THIS DIMENSION IS A REFERENCE FOR THE	CP	- Acceptable. - Relationship between inside face and bore the same, will sit on stuble the same.	10.12.02	10/12/03	CP	10/12.06
10-12-2	100	1.135" + 1.575" BORES. R.E.: OPERATOR ERROR ON OFFSET ENTRY. R.C. LOA	CP	- thickness of stub holes under tolerance by 0.010". But M.S. from SR is 12, i.e. plenty of strength.	10.12.02	10/12/03	CP	10/12.06



NOTE: Date & initial all entries




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Item ID: D2932-1UP Accept  Setup Start   
Revision ID:  
Item Name: 206 Saddle Left side-unpainted Stop   
Start Date: 10/27/2010 Start Qty: 6.00  Cust Item ID:  
Required Date: 11/11/2010 Req'd Qty: 6.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00		<i>Sub 10/12/03</i>		<u>6</u>	<u>0</u>		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00		<i>10/12/03</i>		<u>6</u>	<u>0</u>		
150  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				<u>6</u>	<u>10/12-3.</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 63334**

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Item ID: D2932-1UP

Accept

Revision ID:

Item Name: 206 Saddle Left side-unpainted

Start Date: 10/27/2010 Start Qty: 6.00

Required Date: 11/11/2010 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

57431

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 10/12/06

msf  
10-12-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 1

Wednesday, October 27, 2010 3:51:37 PM

Work Order ID: 63334



Parent Item: D2932-1UP



Parent Item Name: 206 Saddle Left side-unpainted


Start Date: 10/27/2010

Required Date: 11/11/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-07-04 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003  Saddle Billet, 7075		Manufactured	No			100	Each	37.0000	1	6			

*10-12-2*

Location

Loc Qty

Loc Code

MAT042

37

61250

37

*63540*

*(X6)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 63334
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b> D2932-1
<b>Inspection Dwg:</b> D2932 Rev. C	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions					
				1	2	3	4	5	6
A	0.100	0.140	✓	.120	.120	.120	.120	.120	.120
B	0.100	0.140	✓	.120	.120	.120	.120	.120	.120
C	0.100	0.140		.135	.135	.135	.135	.135	.135
D	0.210	0.230		.220	.220	.220	.220	.220	.220
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		.513	.513	.513	.513	.513	.513
I	1.572	1.582		1.578	1.578	1.578	1.578	1.578	1.578
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		.257	.257	.257	.257	.257	.257
L	0.312	0.317		.314	.314	.314	.314	.314	.314
M	0.235	0.240		.238	.238	.238	.238	.238	.238
N	0.100	0.140		.115	.115	.115	.115	.115	.115
O	0.540	0.560		.550	.550	.550	.550	.550	.550
P	0.490	0.510		.502	.502	.502	.502	.502	.502
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720	3.720
R	2.470	2.510		2.490	2.490	2.490	2.490	2.490	2.490
S	0.240	0.270		.250	.250	.250	.250	.250	.250
T	0.100	0.180		.133	.133	.133	.133	.133	.133
U	1.625	1.635		1.630	1.630	1.630	1.630	1.630	1.630
V	1.362	1.372		1.367	1.367	1.367	1.367	1.367	1.367
W	0.316	0.321		.316	.316	.316	.316	.316	.316
X	1.125	1.145		1.133	1.133	1.133	1.133	1.133	1.133
Y	1.565	1.585		1.566	1.566	1.566	1.566	1.566	1.566
Z	0.178	0.198		.188	.188	.188	.188	.188	.188
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>[Signature]</i>
Date: 10.12.2

Audited by: <i>[Signature]</i>
Date: 10/12/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

SHOP COPY  
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ENGINEERING

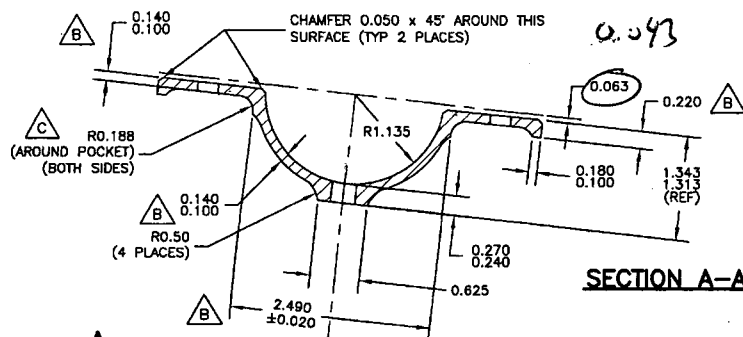
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SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER

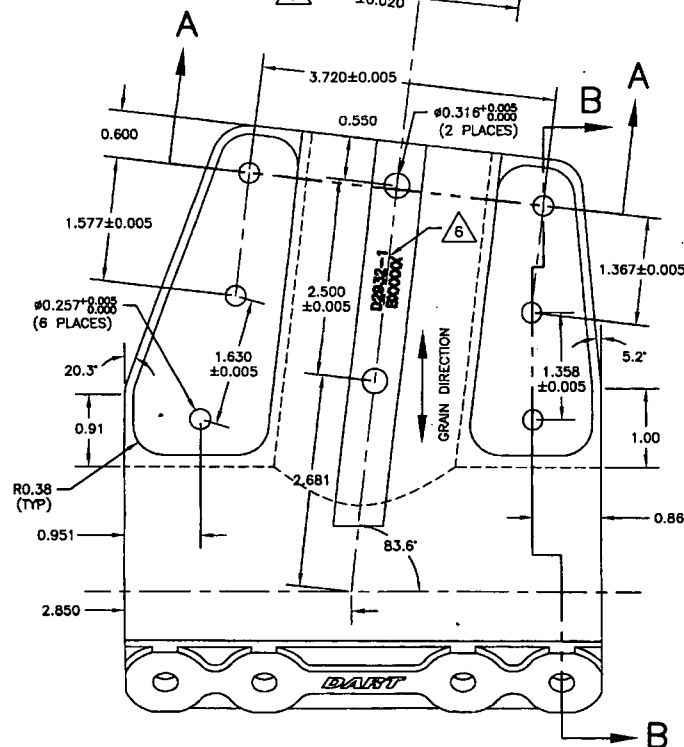
NO 63334

2/10-10-28

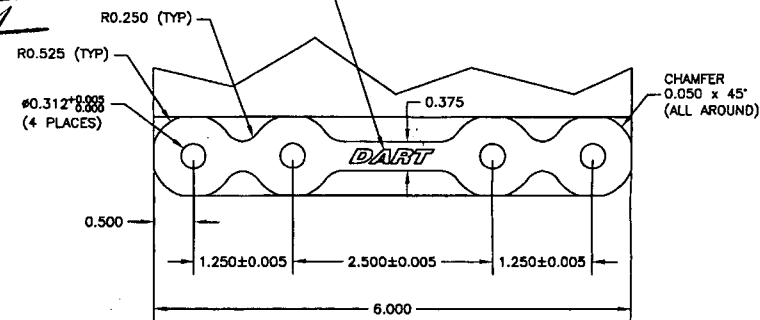
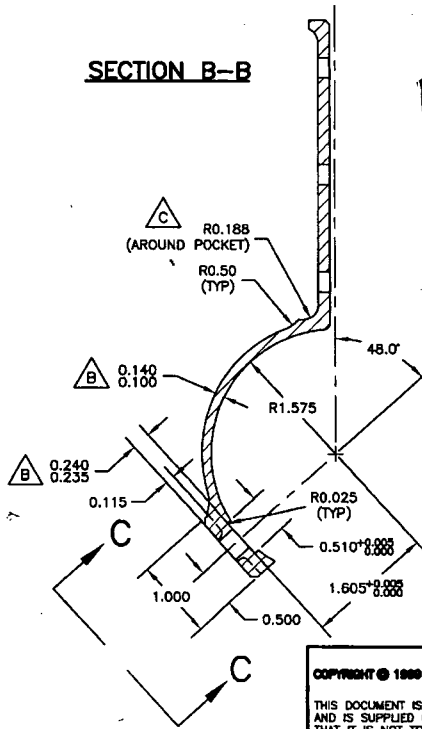
ENGRAVE DART LOGO TO MAX DEPTH  
OF 0.005 WITH MIN RAD 0.250



SECTION A-A



SECTION B-B



VIEW C-C

D2932-1 LH SADDLE (SHOWN)  
D2932-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	BY	DRAWN BY
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE OUTSIDE
		SCALE
		2:3

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DART AEROSPACE USA, INC.

DART DART AEROSPACE USA, INC.  
BELLINGHAM, WA

DRAWING NO.  
D2932

REV. C  
SHEET 1 OF 1

RELEASED

07-02-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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